

For Restricted Circulation only

SHAKAMBHARI ISPAT & POWER LTD.
(Formerly known as Ess Dee Aluminium Ltd.)

STANDARD OPERATING PROCEDURE

Title: Sampling Plan			Page No. 1 of 3
SOP No.	Version No.	Effective Date	Next review date
SIPL/QCS/004	00	06.07.2026	05.07.2028

1.0 PURPOSE

- 1.1 To define a procedure for the sampling plan for incoming material, online process stage, and finished stage.

2.0 SCOPE

- 2.1 This SOP applies to all material which is to be tested for quality.

3.0 REFERENCE(S) & ATTACHMENTS

3.1 References

- 3.1.1 In-house

3.2 Attachments

- 3.2.1 Nil

4.0 RESPONSIBILITY

- 4.1 **QC Department Head:** To prepare the SOP and its scope.
4.2 **QA Head:** To approve the SOP and to ensure implementation.

5.0 DISTRIBUTION

- 5.1 Quality Assurance
5.2 Quality Control

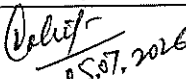
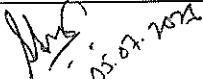
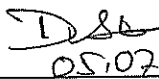
6.0 DEFINITION(S) & ABBREVIATION(S)

6.1 Definitions

- 6.1.1 Nil

6.2 Abbreviations

- 6.2.1 Nil

Prepared By:	Checked By:	Approved By:
 05.07.2026	 05.07.2026	 05.07.2026

**SHAKAMBHARI ISPAT & POWER LTD.**

(Formerly known as Ess Dee Aluminium Ltd.)

STANDARD OPERATING PROCEDURE

Title: Sampling Plan			Page No. 2 of 3
SOP No.	Version No.	Effective Date	Next review date
SIPL/QCS/004	00	06.07.2026	05.07.2028

7.0 PROCEDURE**7.1 RM Sampling Plan:****7.1.1 For Rolls:**

7.1.1.1 For incoming raw material in roll form, the sampling plan below shall be used. The basic rule considered is $\sqrt{n}+1$; however, for a number of rolls below 10, another formula is applied.

7.1.1.2 Sample size shall be one metre in length, and width as actually supplied.

No. of Rolls	Sample to Check
1 to 2	1
3 to 4	2
5 to 6	3
7 to 12	4
13 to 20	5
21 to 30	6
31 to 42	7
43 to 56	8
57 to 72	9
73 to 90	10
91 to 100	11

7.1.2 For Inks/Adhesive/VMCH/Lacquer/Solvent, etc.:

7.1.2.1 For incoming material which comes in containers, one sample per batch shall be taken.

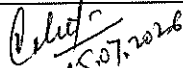
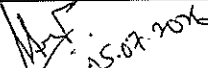
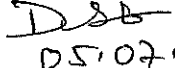
7.1.2.2 Sample size shall be approximately 200 ml.

7.2 On-Line (Production) Sampling Plan:

7.2.1 **Slitting Stage:** One sample per set shall be taken. Total GSM, HSL Coating GSM, visual, and width shall be checked for each and every roll. Sample size shall be about half a metre in length, and width as actual. Layer separation shall be checked per 3 sets.

7.2.2 **Printing Stage:** Each and every output roll shall be sampled and tested for the defined parameters. Sample size shall be one metre in length, and width as actual.

7.2.3 **Doctoring/Inspection Stage:** One sample per set shall be taken. Total GSM, HSL Coating GSM, visual, and width shall be checked for each and every roll, while layer separation shall be checked per 3 sets. Sample size shall be about half a metre in length, and width as actual.

Prepared By:	Checked By:	Approved By:
 05.07.2026	 05.07.2026	 05.07.2026

For Restricted Circulation onlySHAKAMBHARI
GROUP
#SteelWithin**SHAKAMBHARI ISPAT & POWER LTD.**
(Formerly known as Ess Dee Aluminium Ltd.)**STANDARD OPERATING PROCEDURE**

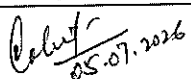
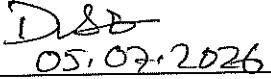
Title: Sampling Plan			Page No. 3 of 3
SOP No.	Version No.	Effective Date	Next review date
SIPL/QCS/004	00	06.07.2026	05.07.2028

7.3 Finished Material:

- 7.3.1 Each batch of finished material shall be checked on a random basis. Two rolls from each batch of finished material shall be checked at the time of dispatch. Checking shall be visual only.

8.0 REVISION HISTORY

Revision No.	00	Effective Date	06.07.2026	CC No.	NA
Details of revision: New SOP					

Prepared By:	Checked By:	Approved By:
 05.07.2026	 05.07.2026	 05.07.2026